



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

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D3391-015
Job Sheet 178460



Part No: D3391-015

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/31/18

Job Tracking No:

Due Date: 5/29/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV J SHEETS 8,10,11 IPP rev A 05.12.13 New issue EC IPP rev B 06.02.09 Dwg @ revD EC IPP rev C 07.03.13 dwg @revF ec IPP rev D 07.10.31 ecn 1053P EC IPP Rev:E ECN 1056 07-11-13 DD verified by: EC IPP Rev:F 08-09-10 revH as per dwg DD verified by:EC IPP Rev:G 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartero.com
www.dartaerospace.com

Container No: S079256



Part: D3391 - 015

Job No: 178460

Serial No/Batch: S079256

Revision:

Inspector:

Exp Date: 06/08/2018

Instructions:

Date: 06/08/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/29/18	0.00	0.00	Start Up Crosstubes		M.D.
100	Mori Seiki	1 pcs		5/29/18	3.56	5.56	Mori Seiki TL-40		M.D.
110	QC	1 pcs		5/29/18	0.00	0.00	QC2-1		M.D. 2018-06-09
120	CNC Vertical Machining	1 pcs		5/29/18	0.00	2.57	HAAS1-3		M.D. 18/06/11
130	QC	1 pcs		5/29/18	0.00	0.00	QC2 Machining-2		S.F. 18-06-13
140	QC	1 pcs		5/29/18	0.00	0.00	QC8 Machining-2		M.D.
150	Skidtubes	1 pcs		5/29/18	0.00	2.07	Skidtubes-3		M.D.
160	CNC Bend Skidtubes	1 pcs		5/29/18	0.00	2.57	CNC Bend Crosstube		M.D.
170	QC	1 pcs		5/29/18	0.00	0.00	QC5		M.D.
180	Skidtubes	1 pcs		5/29/18	0.00	2.07	Skidtubes-4		M.D.
190	QC	1 pcs		5/29/18	0.00	0.00	QC5		M.D.
200	HandFinish	1 pcs		5/29/18	0.00	0.60	HandFinish1		M.D.
205	QC	1 pcs		5/29/18	0.00	0.00	QC7-2		M.D.
210	Skidtubes	1 pcs		5/29/18	0.00	2.07	Skidtubes-4		M.D.
220	QC	1 pcs		5/29/18	0.00	0.00	QC5		M.D.
225	HandFinish	1 pcs		5/29/18	0.00	0.60	HandFinish2		M.D.
230	SprayPaint	1 pcs		5/29/18	0.00	0.63	Spray Paint		M.D.
240	QC	1 pcs		5/29/18	0.00	0.00	QC14		M.D.
250	HandFinish	1 pcs		5/29/18	0.00	0.60	HandFinish4		M.D.
260	QC	1 pcs		5/29/18	0.00	0.00	QC5		M.D.
270	Packaging	1 pcs		5/29/18	0.00	0.00	Packaging3-1		M.D.
280	QC21-SA	1 Ea		5/29/18	0.00	0.00	QC21		M.D.

Part Op 100 - Turn as per Folio FA599 Rev: J & Dwg D3391 Rev: J ****REMOVE STEADY REST AND MACHINIG
 Descriptions: MARKS****

120 - 1-Machine as per Folio FA 599 Rev: J & Dwg D3391 Rev: J 2-Deburr

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803 **Add tangent as per Folio-11**

160 - Form as per Dwg D3391 **Folio -11**

180 - 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391 (All holes) 3-Drill wearplate holes as per Dwg D3391 using DT8878 (Mid Tube) & DT8217 Wearplate Jig . ****Do Not Open To Finished Size**** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5- Tranfer holes from D3391-013 for electric step 0.187" hole D3391 section cc-cc 6- Using DT10247 and drill holes for nutplates, Detail DD, open (5) forward wearplate holes 0.375", and c'sink. 7-Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX FARTHEST AFT HOLES ONLY*** 8-C'bore section cc-cc and open to finish size 9- Open float bag holes to 0.328" as per Dwg D3391, and c'sink 10-Deburr

210 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 507035 exp. date : 19-05-01 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Deburr

225 - REALODINE AS PER PAR09-043

230 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 507035 PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT:

250 - 1- Install nutplate using MS20601AD4W4 (qty12) in the six most forward holes and MS20601AD4W9 (qty8) in the four aft holes. Rivet nutplates as per section TT on sheet 11. 2-Install inserts per dwg D3391 3-Install Aft Cap as per Dwg D3391 A/R Sikaflex-241/-291 507035 Sikaflex expiry date: 19-05-01 4- INSTALL WEARPLATE AS PER DWG

Antsource P041016 SEP 17 2018

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9-89

SEP 19 2018 fed'd

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B139427

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6014-090	Aluminum Extrusion	1 Ea (1 ea)	90-Start up Operation	
NAS1149C0332R	Washer	10 Ea (10 ea)	90-Start up Operation	5071663
D3670-4-200	Bushing	14 Ea (14 ea)	210-Skidtubes	5077425 (KS) 5081002 (9x)
ALS4-1032-130	Rivnut	8 Ea (8 ea)	250-HandFinish	5007221
ALS4-1032-225	Rivnut	4 Ea (4 ea)	250-HandFinish	5058138
ALS4-428-165	Insert	4 Ea (4 ea)	250-HandFinish	5058145
AN3C4A	Bolt	6 Ea (6 ea)	250-HandFinish	5095223
AN3C5A	Bolt	4 Ea (4 ea)	250-HandFinish	5095214
D2646	Aft Cap	1 Ea (1 ea)	250-HandFinish	F163254
D3672-1	Washer, Phenolic	2 Ea (2 ea)	250-HandFinish	F163255-1
D4095-047	Wearpad Aft	1 Ea (1 ea)	250-HandFinish	5025094
D4095-049	Wearpad Aft	1 Ea (1 ea)	250-HandFinish	5063239
MS20601-AD4W3	Rivet	12 Ea (12 ea)	250-HandFinish	5097087
MS20601-AD4W7	Rivet	8 Ea (8 ea)	250-HandFinish	m137148
MS21075L5	Nut Plate	10 Ea (10 ea)	250-HandFinish	5004058

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6014-090	1	21	0
	NAS1149C0332R	10	6,681	0
210-Skidtubes	D3670-4-200	14	32	0
250-HandFinish	ALS4-1032-130	8	13,829	0
	ALS4-1032-225	4	4,997	0
	ALS4-428-165	4	108	0
	AN3C4A	6	1,908	0
	AN3C5A	4	1,947	0
	D2646	1	90	0
	D3672-1	2	1,088	0
	D4095-047	1	27	0
	D4095-049	1	36	0
	MS20601-AD4W3	12	1,307	0
	MS20601-AD4W7	8	169	0
	MS21075L5	10	454	0

Part Specifications

Specifications could not be found.

Plex 5/31/18 2:23 PM dart.white.jesse

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DART AEROSPACE LTD		Work Order:
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		Tape	
3.500	+/-0.010	3.503	✓		Vern 08	
Ø3.200	+/-0.010	3.202	✓		BH4" 05	
Ø3.750	+/-0.010	3.753	✓		"	
30° x 0.060 chamfer	+/-0.010	.060	✓		Vern 08	
88.93	+/-0.030	88.93	✓		Tape	

Measured by: M.D. PMP	Date: 2018-06-08
Audited by: [Signature]	Date: 18-06-08

HAAS Section						
1.526	+0.000/-0.030	1.518	✓		Vernier	
7.500	+/-0.010	7.502	✓		Vernier	
27.750	+/-0.010	27.750	✓		Tape	
31.750	+/-0.010	31.750	✓		Tape	
35.250	+/-0.010	35.250	✓		Tape	
3.300	+/-0.010	3.301	✓		Vernier	
0.200	+/-0.010	.197	✓		Pin gage / Vernier	
3.520	+/-0.010	3.524	✓		Micrometer	
0.687	+0.010/-0.000	.688	✓		Vernier	
R0.062	+/-0.010	R.062	✓		Gage	
Ø0.484	+0.005/-0.001	Ø.484	✓		Pin gage	

Measured by: M.D. / [Signature]	Date: 2018/06/11
Audited by: DAS	Date: 18-06-13

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

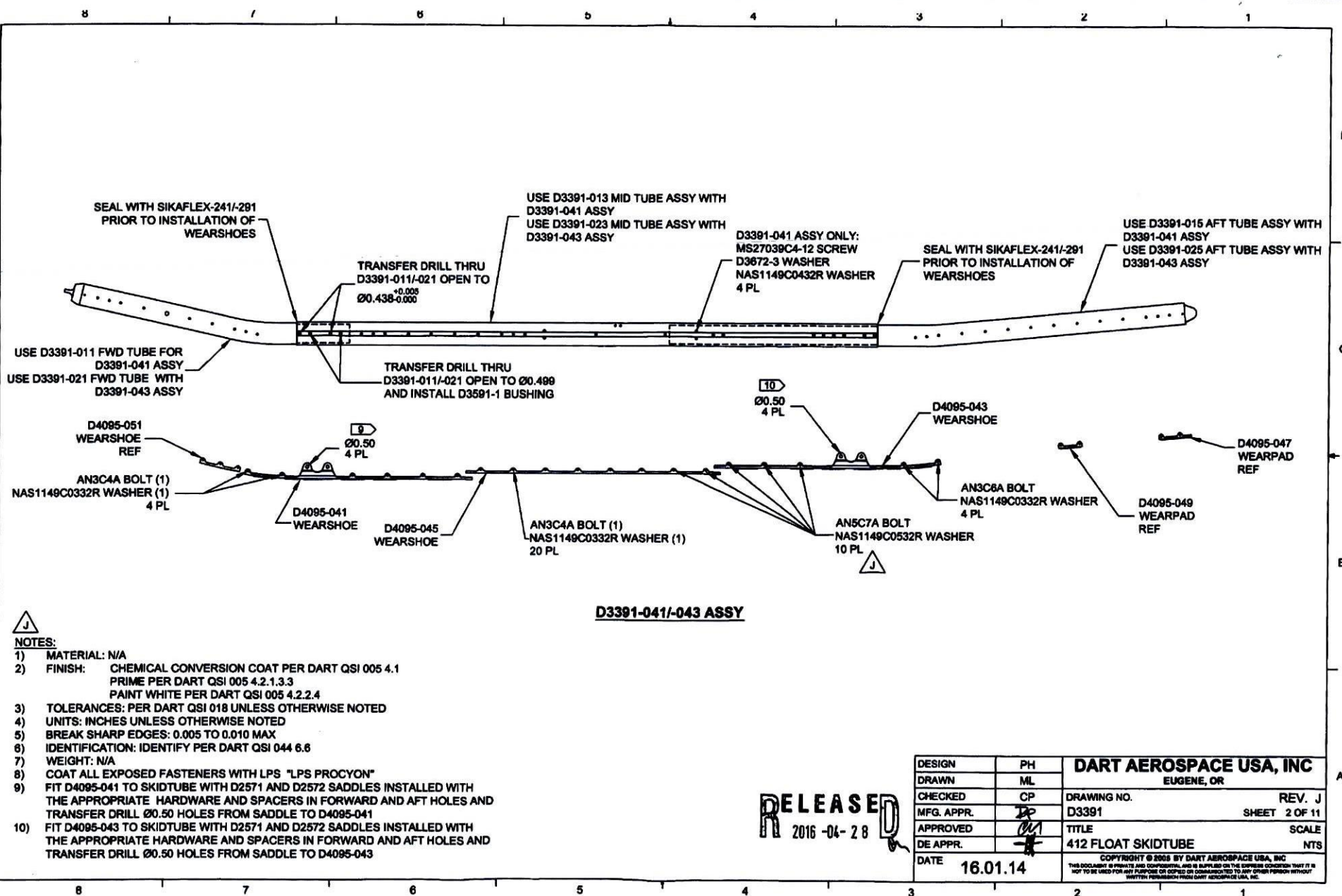
D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

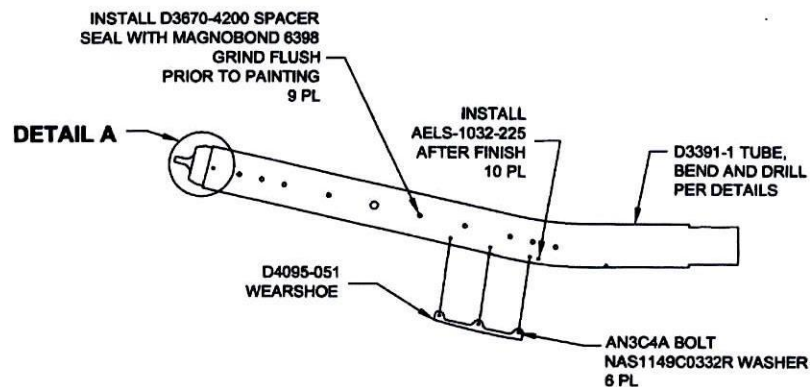
QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3C4A	BOLT
4	4	AN3C6A	BOLT
10	10	AN5C7A	BOLT
28	28	NAS1146C0332R	WASHER
10	10	NAS1146C0332R	WASHER
4		MS27036C4-12	SCREW
4		NAS1146C0432R	WASHER

J

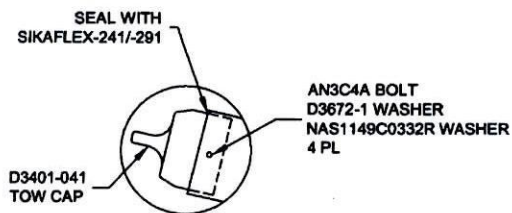
J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	16.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B8-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C8 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C8 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9384 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -0111-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	08.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	08.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 1 OF 11
APPROVED	EP	TITLE	SCALE
DE APPR.	EP	412 FLOAT SKIDTUBE	NTS
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2016-04-28
ECN 16-516

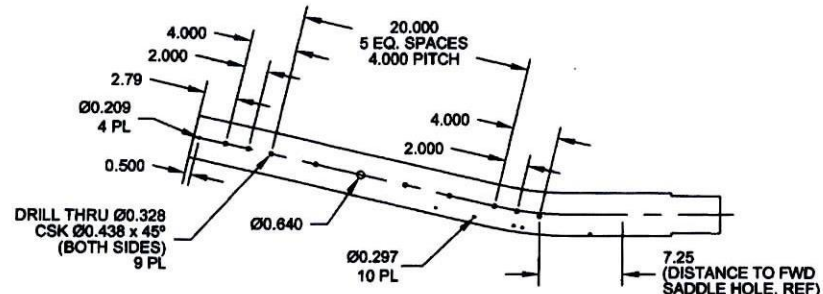




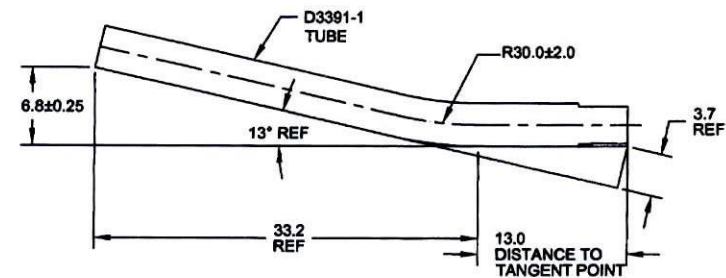
D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL



DETAIL A
SCALE 2X



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER

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DRAWN	ML	EUGENE, OR	
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MFG. APPR.		D3391	SHEET 3 OF 11
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INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



D4095-051
WEARSHOE

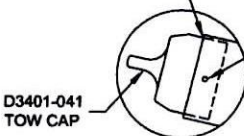
INSTALL
AELS-1032-225
AFTER FINISH
10 PL

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/-291

D3401-041
TOW CAP

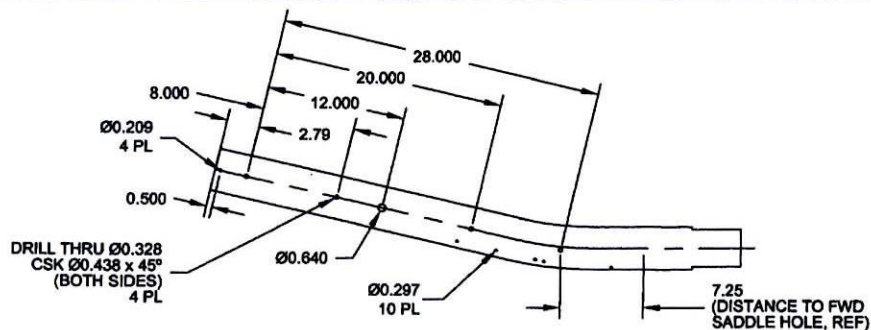


AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

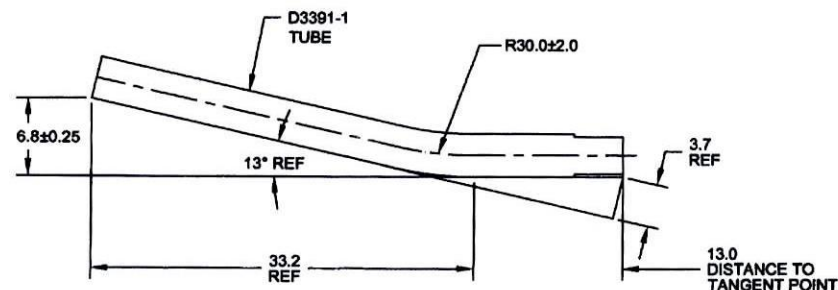
DETAIL B SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



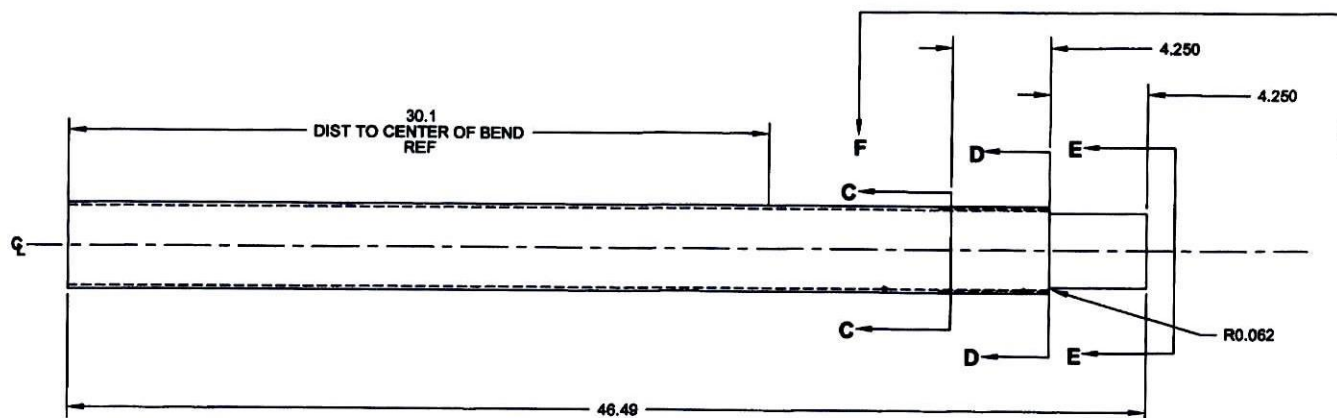
D3391-021 DRILLING DETAIL



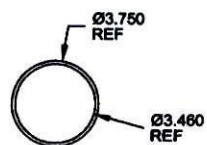
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

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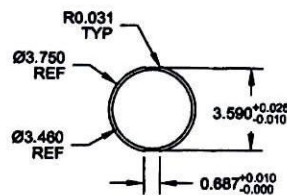
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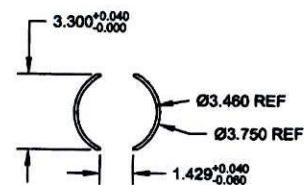
D3391-1 TUBE
(MAKE FROM D8013-047 SKIDTUBE MATERIAL)



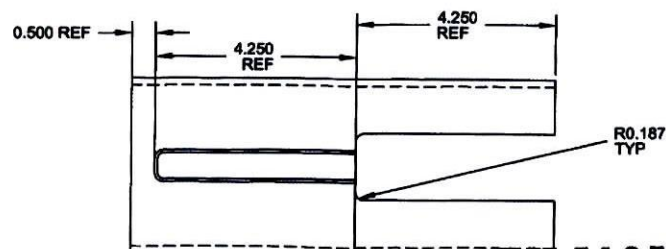
SECTION C-C



SECTION D-D



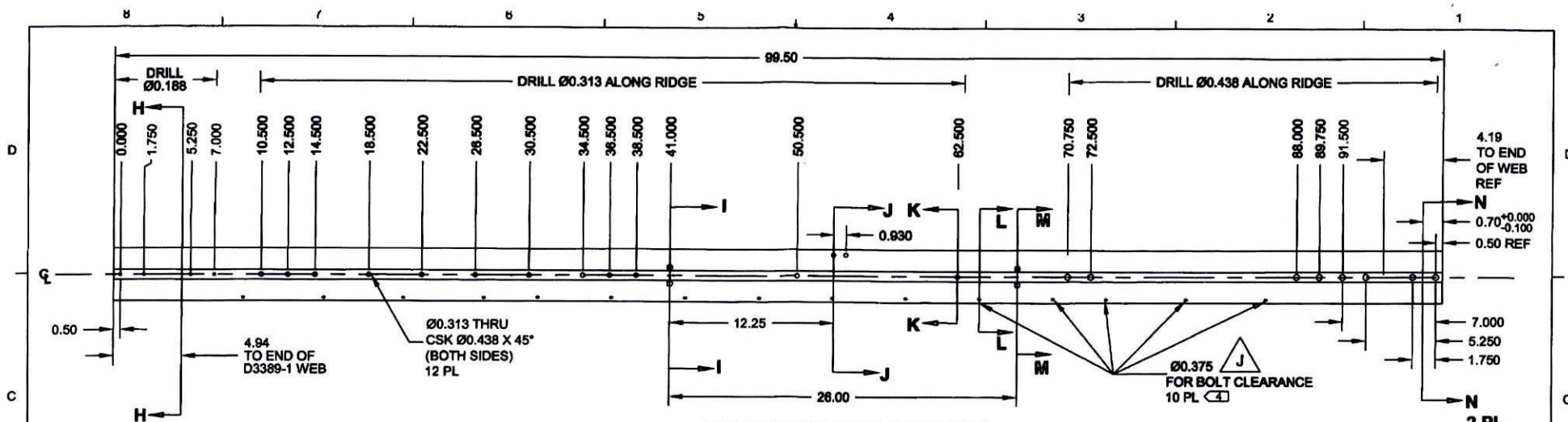
SECTION E-E



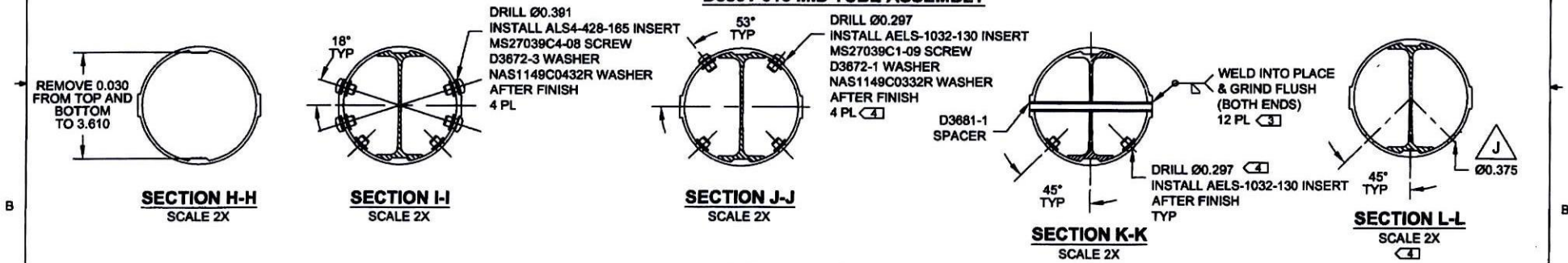
VIEW F-F
SCALE 2X

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2016-04-28

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APPROVED	22	TITLE	SCALE
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D3391-013 MID TUBE ASSEMBLY



D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW
4	NAS1149C0332R	WASHER
4	NAS1149C0432R	WASHER

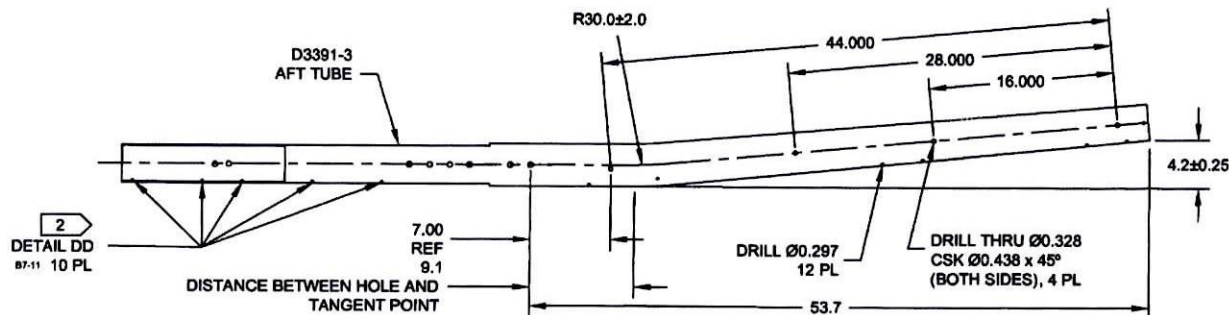
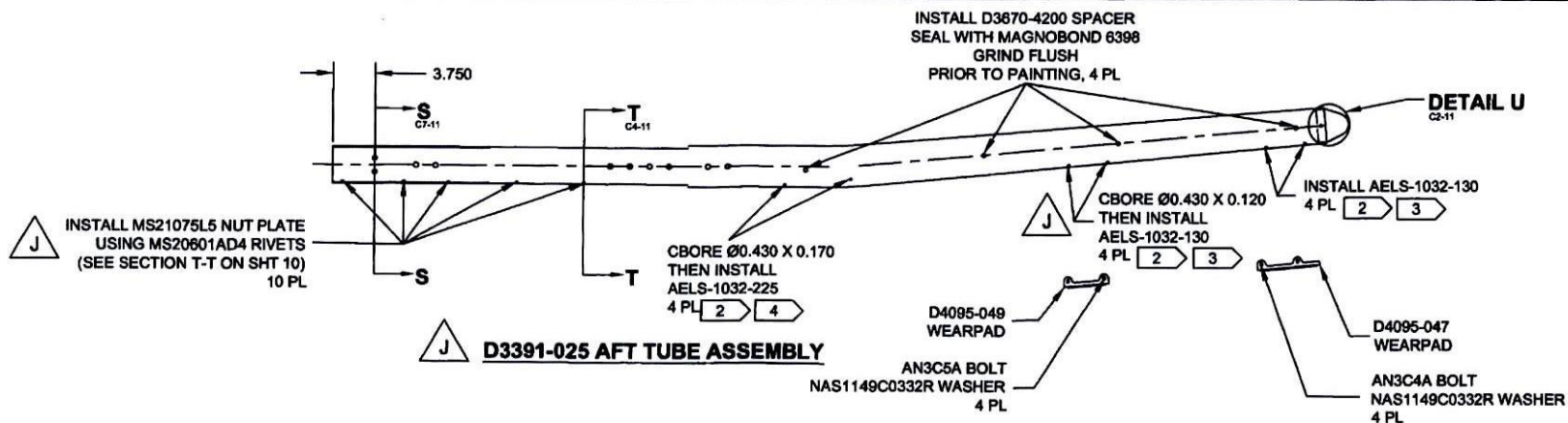
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 AND 0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN		PH	DART AEROSPACE USA, INC EUGENE, OR
DRAWN		ML	
CHECKED		CP	DRAWING NO.
MFG. APPR.			D3391
APPROVED			TITLE
DE APPR.			412 FLOAT SKIDTUBE
DATE		16.01.14	REV. J SHEET 6 OF 11 SCALE NTS

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2016-04-28

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D3391-025 AFT TUBE ASSEMBLY PARTS LIST

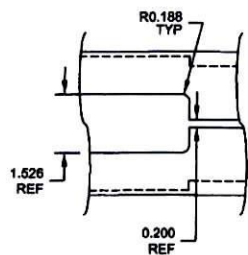
QTY	PART NUMBER	DESCRIPTION
X	D3391-025	AFT TUBE ASSEMBLY
1	D2648	AFT CAP
1	D3391-3	AFT TUBE
4	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE FLOATING
10	NAS1149C0332R	WASHER

NOTES:

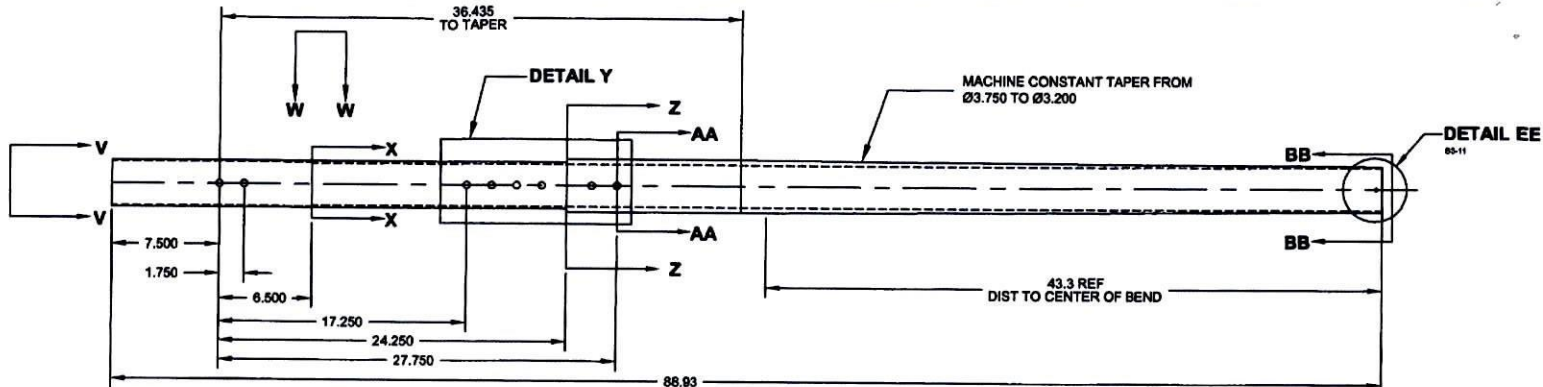
- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

RELEASED
2016-04-28

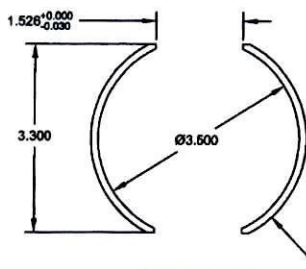
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		AFT TUBE ASSEMBLY	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



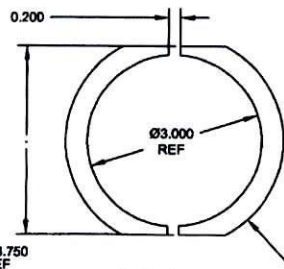
VIEW W-W
SCALE 4X



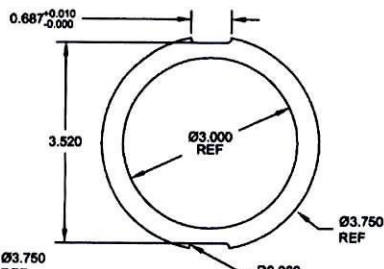
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090)



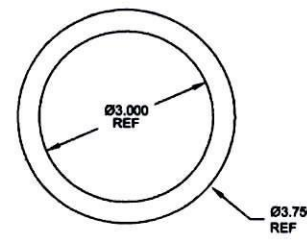
SECTION V-V
SCALE 4X



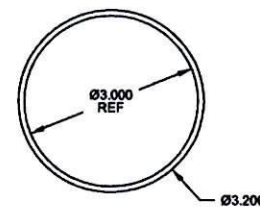
SECTION X-X
SCALE 4X



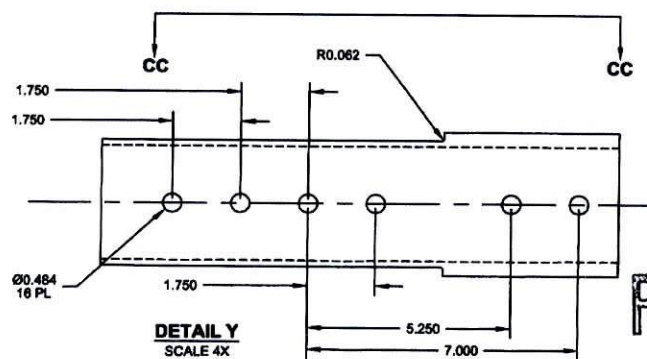
SECTION Z-Z
SCALE 4X



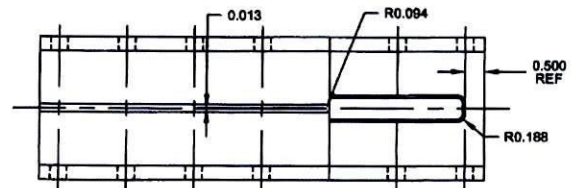
SECTION AA-AA
SCALE 4X



SECTION BB-BB
SCALE 4X



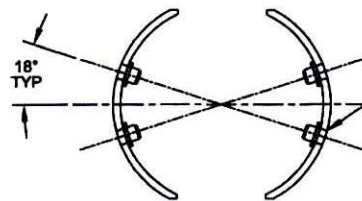
DETAIL Y
SCALE 4X



VIEW CC-CC

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2016-04-28

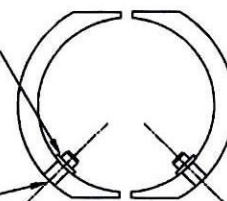
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DEF	D3391	SHEET 10 OF 11
APPROVED	DEF	TITLE	SCALE
DE APPR.	DEF	412 FLOAT SKIDTUBE	NTS
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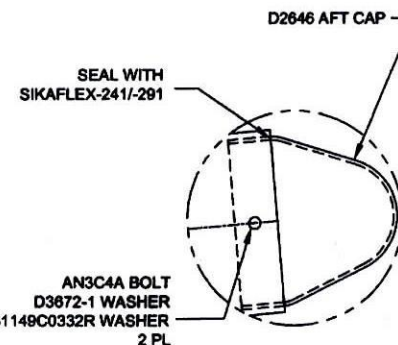
SECTION S-S D6-4.9
SCALE 5X

MS21075L5 NUTPLATE REF
USE DT8217 DRILL TEMPLATE
TO LOCATE HOLES AND OPEN
TO Ø0.375

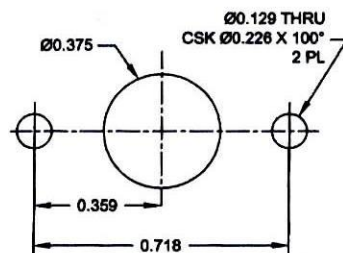
DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



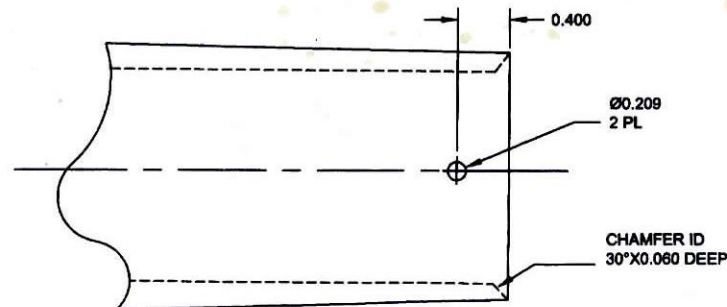
SECTION T-T D6-4.9
SCALE 5X
5 PL



DETAIL U D1-4.9
SCALE 5X



DRILLING DETAIL DD D7-4.9
SCALE 10X



DETAIL EE D1-11
SCALE 2X

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

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CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	YR	D3391	SHEET 11 OF 11
APPROVED	MS	TITLE	SCALE
DE APPR.	CH	AFT TUBE ASSEMBLY	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041016**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041016
PO Date: 9/14/18
Due Date: 9/17/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177479	D3391-011	Fwd Tube Assembly : Various STC's	Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
2	178458	D3391-013	Mid Tube Assembly : Various STC's	Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
	178430			Firmed		9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
Sub Total:							2	0	2		\$760.00
3	178431	D3391-015	Aft Tube Assembly : Various STC's	Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
	178460			Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
Sub Total:							2	0	2		\$760.00
Grand Total:										\$1,900.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/17/18 9:00 AM dart.lavoie.chantal



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SUBCONTRACT SHIPPER

SUBCONTRACT SHIP TO

Ship To: Atelier Debosselage
358 Principale
Calumet, QC J0V 1B0 Canada
Phone: 819 242 5633 **Fax:**

SHIPPER

Shipper No: 624
Shipper Date: 9/17/18
Carrier: *
Ship Via:
Vehicle Reg:
Note:
Freight Terms:

Part Information

Part No: D3391-011
Cust Part No:
Reference No:
Part Information Note: DWG REV J SHEETS 3,5 IPP A 05.09.13 New issue
KJ/JLM IPP B IPP C 07.03.13 revF dwg ec IPP D
07.11.01 ecn1053P EC IPP Rev:E ECN 1056 07-11-
12 DD verified by:EC IPP Rev:F 08-09-08 new
process (ecn 08-510) DD verified by:EC IPP Rev:G
08-09-10 revH as per dwg DD verified by:EC IPP
Rev:H 10.04.07 add part in bom DD verified by:JLM
IPP Rev:I 11.11.14 AS PER REV.I DD verified by:JLM

Name: Fwd Tube Assembly
Product Family: Landing Gear
Piece Weight: 0 lbs
Alloy Type:
Alloy - Temper: -
Description: Various STC's
Quantity:

Drawing No:
Program:
Program Customer:
Addl Docs:
Commercial: Product Line: Landing Gear - Spare
Primary OEM Application: Bell
Manufacturer: DART
Advertised on web?: Yes

OPERATION

Operation: Outsource - 245
Description:
Note:

DETAIL

Part	Operation	PO	Job	Container	Heat Code	Net Weight (lbs)	Gross Weight (lbs)	Quantity
D3391-011	Outsource	PO041016	177479	S076677		0	0	1
D3391-013	Outsource	PO041016	178458	S077079		0	0	1
			178430	S078351		0	0	1
D3391-015	Outsource	PO041016	178431	S079224		0	0	1
			178460	S079256		0	0	1
Total				5		0	0	5

Driver Signature

Customer Copy

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